

**Work Order ID 58484**

May 7, 2010 1:28:42 PM



Page 1

Item ID: D4021-7

Accept



Setup

Start



Revision ID:

Item Name: Hoop

Stop



Start Date: 07/05/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: *PL*Date: *16-5-10*

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D4021	B

100

0.00



Waterjet

Memo

0.00

*16-10-5-10*

FLOW CNC Waterjet

Cut as per dwg D4021  
Prog Rev: *S*  
Dwg Rev: *S*

Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

*16-10-6-10*

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 14/05/2010 Req'd Qty: 6.00



Reference:

Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

120



QC

Quality Control

Operation  
Description

QC8- Inspect parts - second check

Set Up/  
Run Hours

0.00

0.00

0.00

0.00

0.00

0.00

Draw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

S.05/12

46

(6)

7/1/12 10/5/12

130



Small Fab

Small Fab

Memo

- 1- make radius as per dwg
- 2- deburr

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S.05/12

(X6)

(X6)

W/O:		WORK ORDER CHANGES							
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Revision ID:

Item Name: Hoop

Start Date: 07/05/2010 Start Qty: 6.00



Setup Start



Required Date: 14/05/2010 Req'd Qty: 6.00



Stop



Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

150

Operation  
Description

Identify as per dwg &amp; Stock Location: WA

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Packaging

Memo

0.00

6 8

10.05.17

10/05/17 JJ

160



QC21- Final Inspection - Work Order Release

0.00

10-5-17  
4

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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## Picklist Print

May 7, 2010 1:28:47 PM

Page 1

Work Order ID: 58484



Parent Item: D4021-7



Parent Item Name: Hoop

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB DD 10.04.20 verified by:EC

Start Date: 07/05/2010

Required Date: 14/05/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ M304B0.625X3.000	Replacement	Mfg/ Purchased	Bin No	Primary	Last	Route 100	Unit of f	Qty on 5.7147	Qty per Kit 0.4166	Qty	Date	Status
304 BAR .625 X 3.00											BR 10-5-10	

Location	Loc Qty	Loc Code
MAT53	5.7147	
112320	5.7147	112320

⑥

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NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<i>58484</i>
<b>Description:</b> Hoop	<b>Part Number:</b>	<b>D4021-7</b>
<b>Inspection Dwg:</b> D4021 <b>Rev:</b> A		<b>Page 1 of 1</b>

## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

Measured by: <u>TP</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: 10-5-10	Date: 10/07/10	Date: N/A

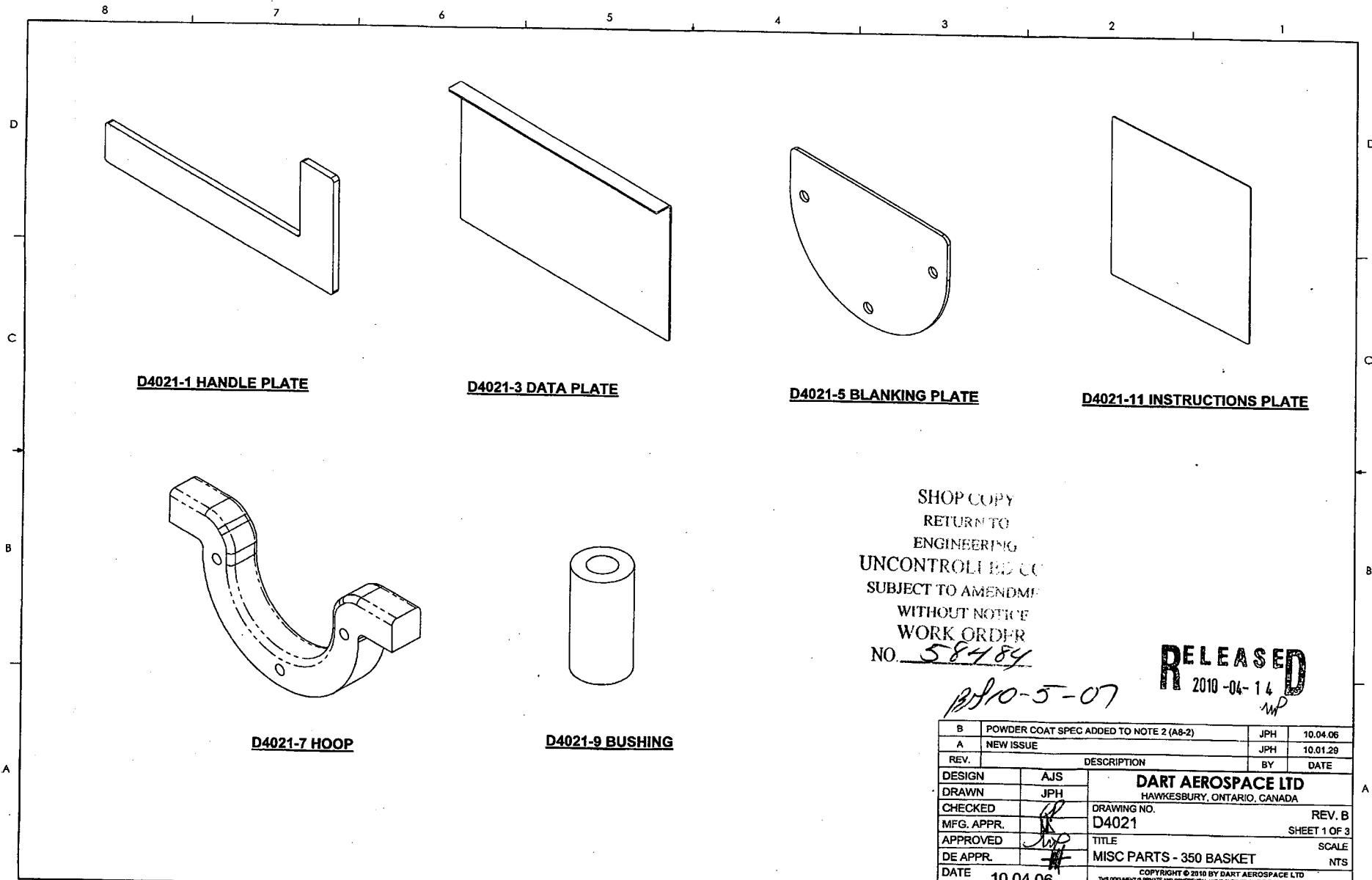
Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



W/O: \_\_\_\_\_

**WORK ORDER CHANGES**

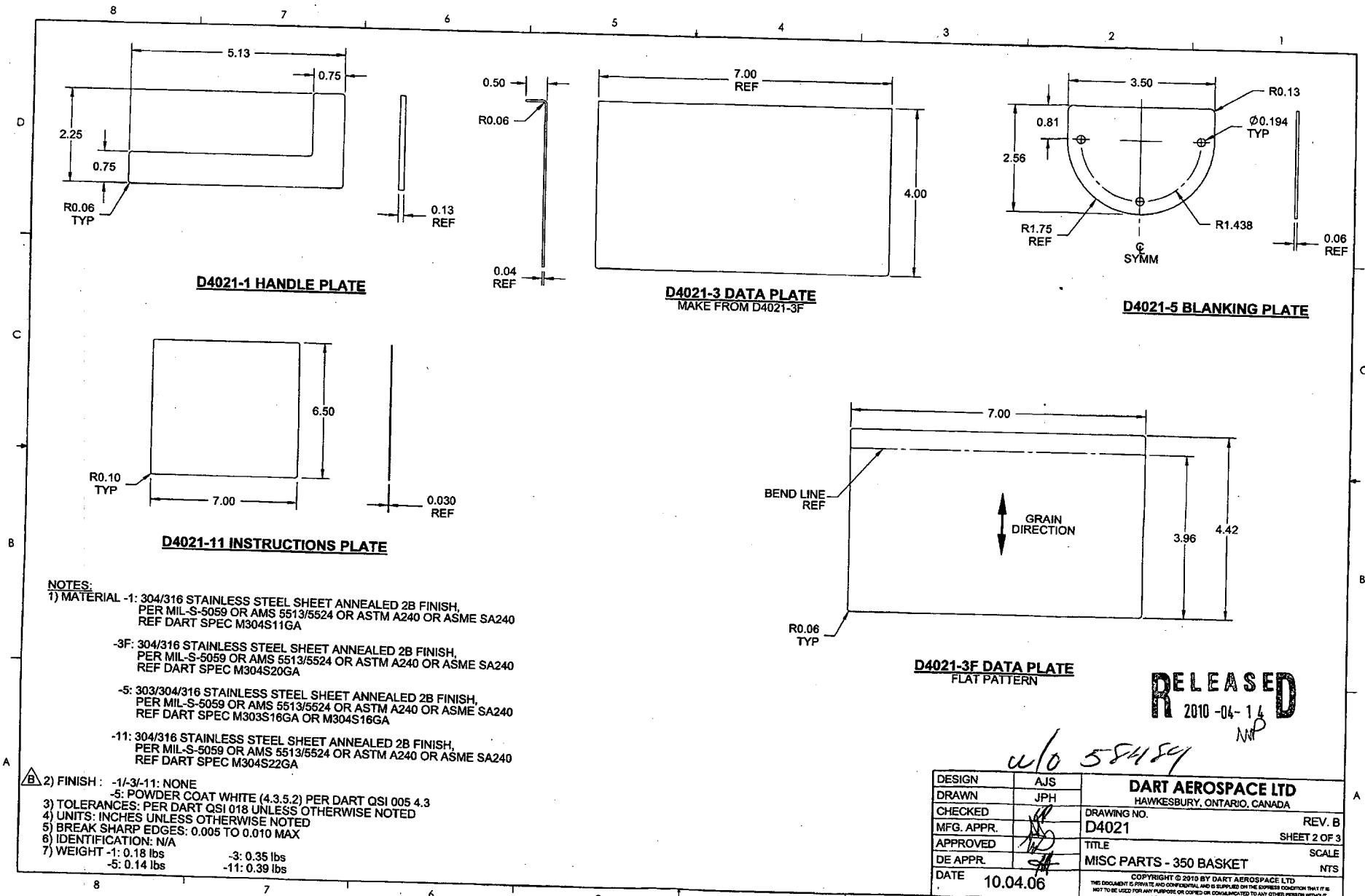
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DESIGN	AJS	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	W	DRAWING NO.
MFG. APPR.	W	REV. B
APPROVED	W	SHEET 2 OF 3
DE APPR.	W	TITLE
DATE	10.04.06	SCALE
		NTS
		MISC PARTS - 350 BASKET

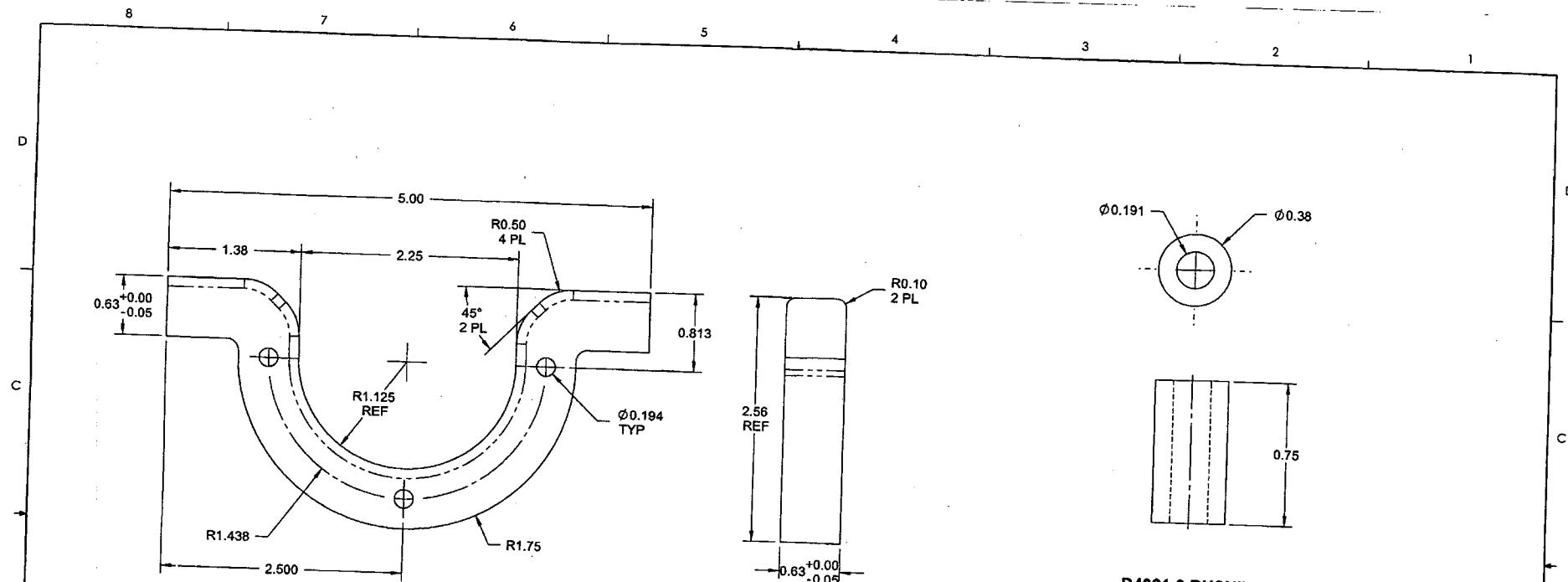
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D4021-7 HOOP

D4021-9 BUSHING

NOTES:

- 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276  
REF DART SPEC M304B
- 9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276  
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -7: 0.80 lbs  
-9: 0.02 lbs

W058484

RELEASED  
2010-04-14  
NMP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	
MFG. APPR.	MP	D4021	REV. B
APPROVED	MP		SHEET 3 OF 3
DE APPR.	MP	TITLE	SCALE
DATE	10.04.06	MISC PARTS - 350 BASKET	NTS

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